

Date: Monday, 12/01/2009 2:30:08 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SEAT FRAME ASSEMBLY
<b>Job Number</b> :	44556		
<b>Estimate Number</b> :	11122		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3016041
<b>This Issue</b> :	12/01/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3016 REV A
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	43600	<b>Drawing Revision</b> :	A
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>JLD 09.01.12</u>	<b>Due Date</b> :	30/01/2009
<b>Comment</b> :	Est. A 01.09.19 New issue EC	<b>Qty:</b>	1 Um: Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M4130NT0750W049	4130 RD Tube .750 x.049W
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**Comment:** Qty.: 4.5150 f(s)/Unit Total : 4.5150 f(s)  
 4130 Tube .750 OD x.049W  
 Cut- AISI 4130N tube, Ø3/4" x 0.049" wall  
 Batch: M11642

L7 9-6-18

2.0	M4130NT1000W120	4130 RD Tube 1.00 x .120wall
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**Comment:** Qty.: 1.5750 f(s)/Unit Total : 1.5750 f(s)  
 4130 Tube 1.0"D X 0.120"W  
 batch M108538

L7 9-6-18

3.0	M4130NT0500W049	4130 RD Tube .500 x.049W
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**Comment:** Qty.: 4.5150 f(s)/Unit Total : 4.5150 f(s)  
 4130 Tube .500 OD x.049W  
 Cut- AISI 4130N tube, Ø1/2" x 0.049" wall  
 Batch: M106651

L2 9-6-18

4.0	D301617	Gusset
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Gusset  
 Pick:

Qty	Part Number	Description	Batch
2	D3016-17	Gusset	<u>639641</u>

EL 9-6-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 12/01/2009 2:30:08 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT FRAME ASSEMBLY

Job Number: 44556

Part Number: D3016041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D301613

Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket

Pick:

Qty Part Number Description Batch

2 D3016-13 Bracket 1x B34208 1x B44778

EL 9-6-22

6.0

D301615

Gusset



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Gusset

Pick:

Qty Part Number Description Batch

2 D3016-15 Gusset B3413

EL 9-6-22

7.0

D30201

Fitting



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Fitting

Pick:

Qty Part Number Description Batch

4 D3020-1 Fitting B36713

EL 9-6-22

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut all tubes as per Dwg D3016

2-Deburr

3-Assemble and weld as per Dwg D3016 using welding jig DT8597

A/R 4130 Rod Batch: M102226

4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041

EL 9-6-22

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 9-6-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 12/01/2009 2:30:08 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT FRAME ASSEMBLY

Job Number: 44556

Part Number: D3016041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

502/06/23 (X) set

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Install paint screws on fitting ends

Powder Coat Grey sandtex (Ref. 4.3.5.6) as per QSI 005

START TIME: 11:30am

OVEN TEMPERATURE: 320°C

FINISH TIME: 12:00pm

41 09-04-24 (X)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-06-24 (D)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

9/6/24

(X) SL

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24 (X)

Job Completion



C 209/06/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

#### NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

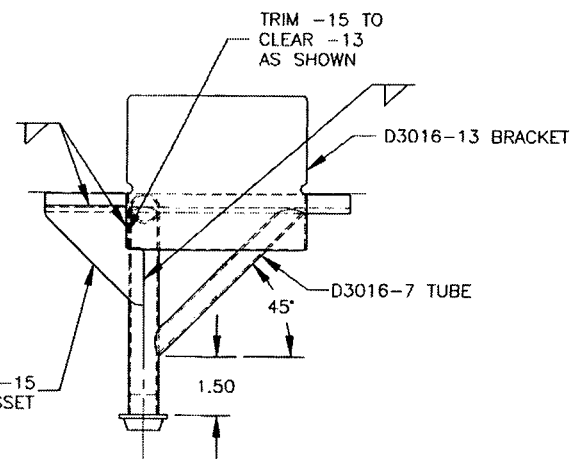
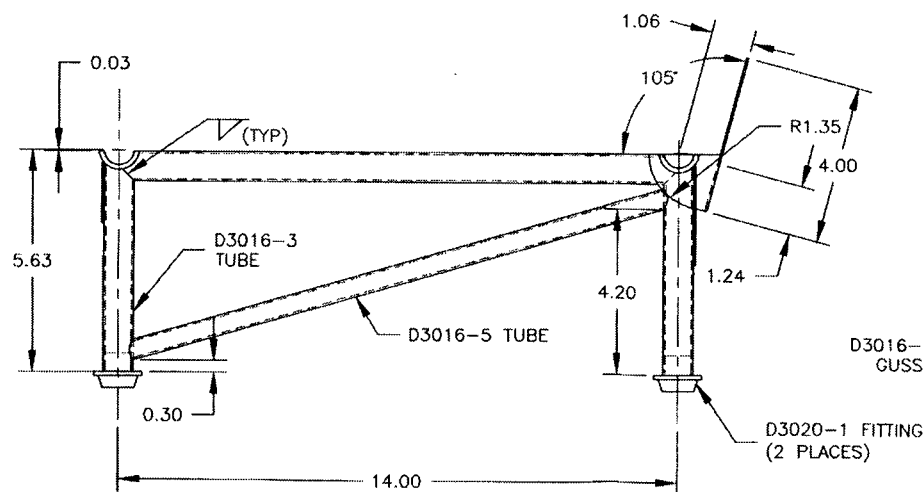
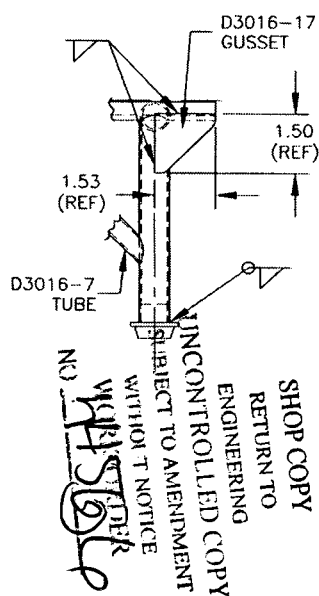
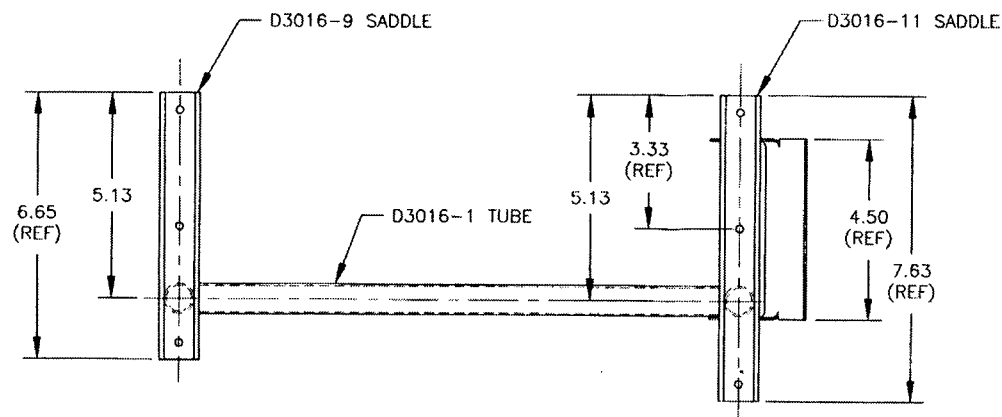
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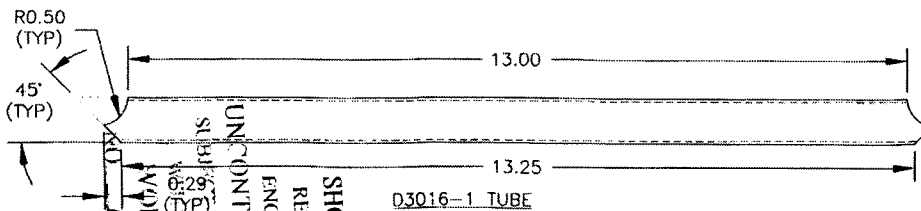
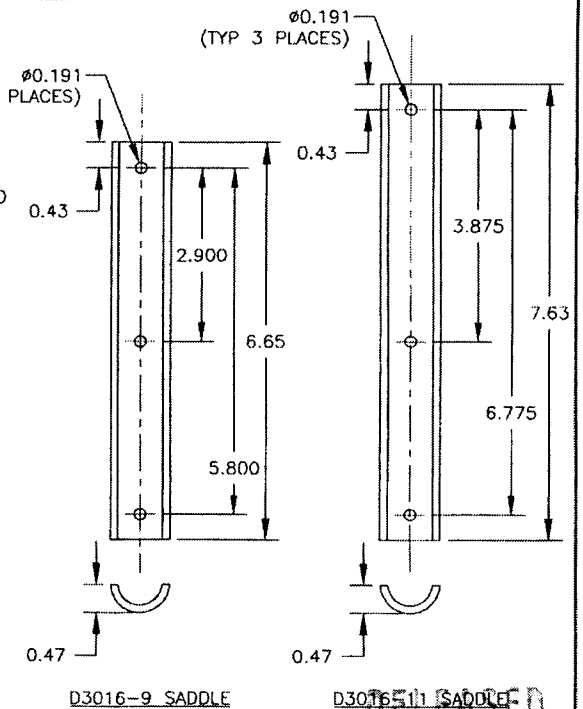
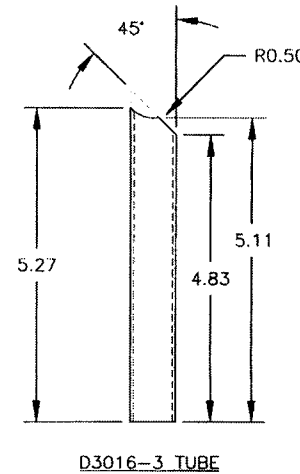
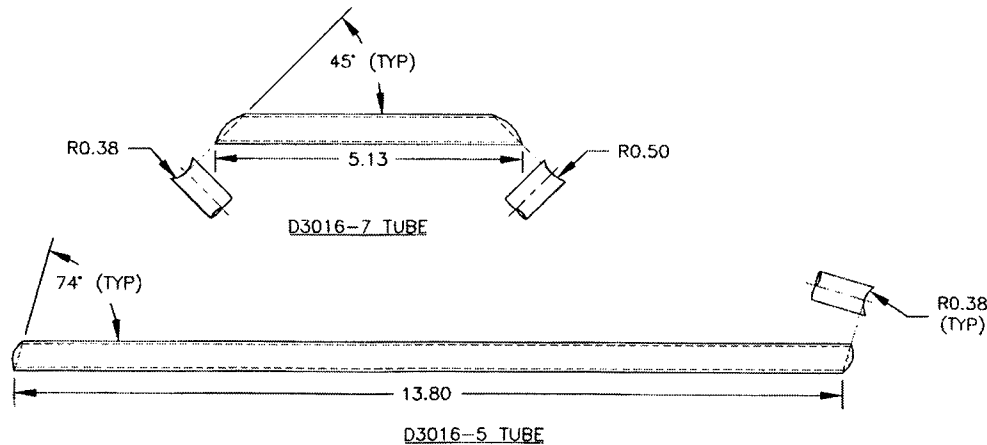
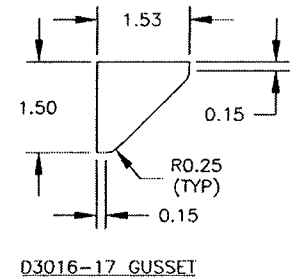
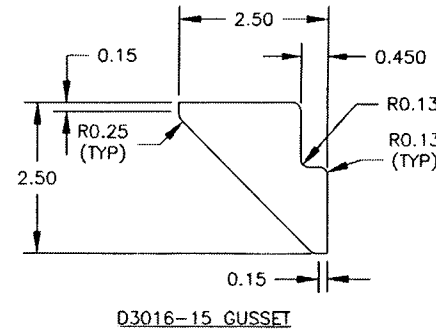
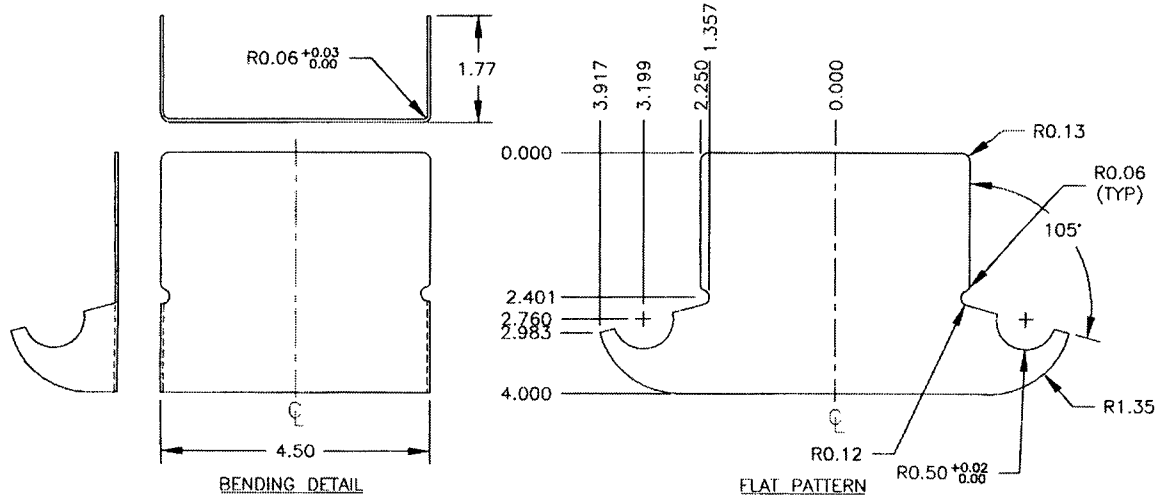
# D3016-041 SEAT FRAME ASSEMBLY



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DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY		SCALE 1:3	





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